

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-005186**Date Inspected:** 31-Dec-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 645**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1845**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Fu Guo gang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Components**Summary of Items Observed:**

On the date Caltrans OSM Quality Assurance (QA) inspector Mike Blair was present during the times noted above for observations relative to the work being performed.

Radiograph Review

This QA Inspector reviewed Welder Qualification Test radiographs and concur with reports as stated.

Bay 10-Tower**Ultrasonic Testing**

The QA Inspector performed Ultrasonic Testing (UT) on approximately 25% of the area previously tested and accepted by ZPMC Quality Control personnel. The QA Inspector generated an Ultrasonic report for this date. The member is identified as:

NSD1-SA61F/G. The weld designations are as follows: 9, 10

NSD1-SA166A/F. The weld designations are as follows: 2

SD1-SA250-77M-1. The weld designations are as follows: 1

ND1-SA250-33M-1. The weld designations are as follows: 1

Work in progress

This QA Inspector observed the following work in process: SAW welding of weld joint 11 located on NSD1 SA171C/D. Welder is identified as 050295. ZPMC QC is identified as Liu Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-B-U3c-2.

WELDING INSPECTION REPORT

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This QA Inspector observed the following work in process: FCAW welding of weld joint 4 located on NSD1 SA105. Welder is identified as 200119. ZPMC QC is identified as Liu Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2231-Tc-U5-F.

Bay 11-Tower

Ultrasonic Testing

The QA Inspector performed Ultrasonic Testing (UT) on approximately 25% of the area previously tested and accepted by ZPMC Quality Control personnel. The QA Inspector generated an Ultrasonic report for this date. The member is identified as ESD1-SA99. The weld designations are as follows: 4

Work in progress

This QA Inspector observed in-process Flux Core Arc Welding (FCAW) tack welding and fit-up of longitudinal stiffener plates on WSD1-SA295A/E

Unless otherwise noted, all observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod, 134-8257-0045, who represents the Office of Structural Materials for your project.

Inspected By:	Blair,Mike	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
